

Work Order ID 79340***79340***

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Wednesday, January 25, 2012 11:58:47 AM

Item ID: D2364 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Deck Plate, Fwd 350 Litt
Start Date: 1/25/2012 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 2/3/2012 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: M.C.J. Date: 12/01/25 Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2364	Rev F
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100

0.00

100

Waterjet

FLOW CNC Waterjet

FLOW WATER JET

Memo

1-Cut as per Dwg D2364 Dwg Rev: F Prog Rev: F 2-
Deburr if necessary

0.00

110

0.00

110

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

120

0.00

120

QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

W 12 02 07 (4)

W 12 02 07 (4)

(44)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

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130

0.00

130

Small Fab

Small Fab

Memo

0.00

Small Fab

1- counter sink holes as per dwg D23642- deburr if necessary

140

0.00

140

QC5- Inspect part completeness to step on W/O

QC

Memo

0.00

Quality Control

150

0.00

150

Chemical Conversion Coat per QSI005 4.1

HandFinish

Memo

0.00

Hand Finishing

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160	Black Sandtex(Ref:4.3.5.7) per QSI005 4.3	0.00							
160									
Powdercoat	Memo	0.00							
Powder Coating	START TIME: 3:30								
	FINISH TIME: 4:00								
	32001								
170	QC3- Inspect Part Finish	0.00							
170									
QC	Memo	0.00							
Quality Control									
180	Identify as per dwg & Stock Location 224	0.00							
180									
Packaging	Memo	0.00							
Packaging									

4X6 M-L 12/02/15

4 BK 12.2.15.

12/12/15 (Y)

M 115128

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Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
190	QC21- Final Inspection - Work Order Release	0.00							
190									
QC	Memo	0.00							
Quality Control									

MLJ 12/02/17

R 12-02-16

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Picklist Print

Page 1

Wednesday, January 25, 2012 11:58:54 AM

Work Order ID: 79340

79340

Parent Item: D2364

D2364

Parent Item Name: Deck Plate, Fwd 350 Litt

Start Date: 1/25/2012

Required Date: 2/3/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP REV. E00.06.26Removed P/O for powder coatEC
IPP Rev:F Now On Waterjet 06-07-03 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

217.0000

0.6469

2.723789

**

12 02 07

M2024T3S 063

2024-T3 .063 sheet

Location

Loc Qty

Loc Code

MAT022

217

117392

25

119916

192

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DART AEROSPACE LTD		Work Order:	79340
Description: Litter Deck Plate Kit (350)		Part Number:	D2364
Inspection Dwg: D2364	Rev: F	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
6.624	+/-0.010	6.627	✓		VWV	HB-03
Ø0.171	+0.005/-0.000	0.171	✓		VWV	HB-03
0.354	+/-0.010	0.354	✓		VWV	" "
11.242	+/-0.010	11.248	✓		VWV	Prod-W-5-02
3.031	+/-0.010	3.031	✓		VWV	" "
1.903	+/-0.010	1.906	✓		VWV	" "
1.128	+/-0.010	1.127	✓		VWV	" "
0.354	+/-0.010	0.350	✓		VWV	" "
1.340	+/-0.005	1.335	✓		VWV	" "
2.326	+/-0.010	2.326	✓		VWV	" "
3.312	+/-0.010	3.315	✓		VWV	" "
4.298	+/-0.010	4.293	✓		VWV	" "
5.284	+/-0.010	5.278	✓		VWV	" "
6.151	+/-0.010	6.148	✓		VWV	" "
6.270	+/-0.010	6.266	✓		VWV	" "
0.354	+/-0.010	0.354	✓		VWV	" "
3.031	+/-0.010	3.031	✓		VWV	" "
Ø0.656	+0.005/-0.000	0.656	✓		VWV	" "
5.003	+/-0.010	5.003	✓		VWV	" "
4.605	+/-0.010	4.602	✓		VWV	" "
1.776	+/-0.010	1.777	✓		VWV	" "
0.980	+/-0.010	0.979	✓		VWV	" "
4.487	+/-0.010	4.485	✓		VWV	" "
7.192	+/-0.010	7.196	✓		VWV	" "
7.567	+/-0.010	7.560	✓		VWV	" "
7.942	+/-0.010	7.945	✓		VWV	" "
Ø0.191	+0.005/-0.000	0.191	✓		VWV	" "
Ø0.197	+0.005/-0.000	0.197	✓		VWV	" "
11.145	+/-0.010	11.145	✓		VWV	" "
12.181	+/-0.010	12.181	✓		MT	HB-01
11.378	+/-0.010	11.378	✓		MT	" "
11.776	+/-0.010	11.776	✓		MT	" "
12.173	+/-0.010	12.173	✓		MT	" "
4.690	+/-0.010	4.690	✓		VWV	HB-03
0.250	+0.005/-0.000	0.250	✓		VWV	" "
3.144	+/-0.010	3.144	✓		VWV	" "
0.171	+0.005/-0.000	0.171	✓		VWV	" "

Measured by:	<i>[Signature]</i>	Audited by:	<i>[Signature]</i>	Prototype Approval:	N/A
Date:	12-02-07	Date:	12/07/07	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	04.06.25	New Issue P/O D350-616-015	KJ/JLM	
B	08.05.28	7.567 dimension revised	KJ/DD	

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